

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 33249
Estimate Number : 10428
P.O. Number : N/A
This Issue : 6/28/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Rtn : 30996
Written By :
Checked & Approved By :
Comment : Est A 04.04.19 New issue KJ/JLM

Drawing Name : MOUNTING LUG
Part Number : D32351
Drawing Number : D3235 REV A
Project Number : N/A
Drawing Revision : A
Material : N/A
Due Date : 7/25/2007

Qty: 300 Um: Each

Additional Product

Job Number



Seq. #:

Machine Or Operation:

Description:

1.

D2423

Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 35.8575 f(s)
Lug Extrusion
D2423 extrusion
Batch: 30062

2.

BAND SAW

BAND SAW



Comment: Band Saw
Cut D2423 extrusion to 0.820"
Batch:

issue: P/O: 4091
C20767104 (500)

3.

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine as per Fello FA369 and Dwg D3235
2-Identify as D3235-1
3-Deburr and Tumble

Receiving:

200

7/8/15 300x50

4.

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N/A

300 counter

5.

QC6

SECOND CHECK



Comment: SECOND CHECK

25017 in 07/08/17

07/08/13 (200)

Don check and inspect for transit damage

Process Sheet

Part Number: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 33249

Part Number: D32351

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



800X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M/T 07/08/22
07-08-14

200

7.0

QC5

INSPECT WORK TO CURRENT STEP



En 07/08/23 X300 counter

Comment: INSPECT WORK TO CURRENT STEP

En 07/08/14 X200

8.0

POWDER COATING

POWDER COATING



07/08/23

300

M 105068

200

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

BR/M 07-08-15

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



En 07/08/23 X300

Comment: INSPECT POWDER COAT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

u 07-08-25 300

11.0

QC21

FINAL INSPECTION/W/O RELEASE



300

Comment: FINAL INSPECTION/W/O RELEASE

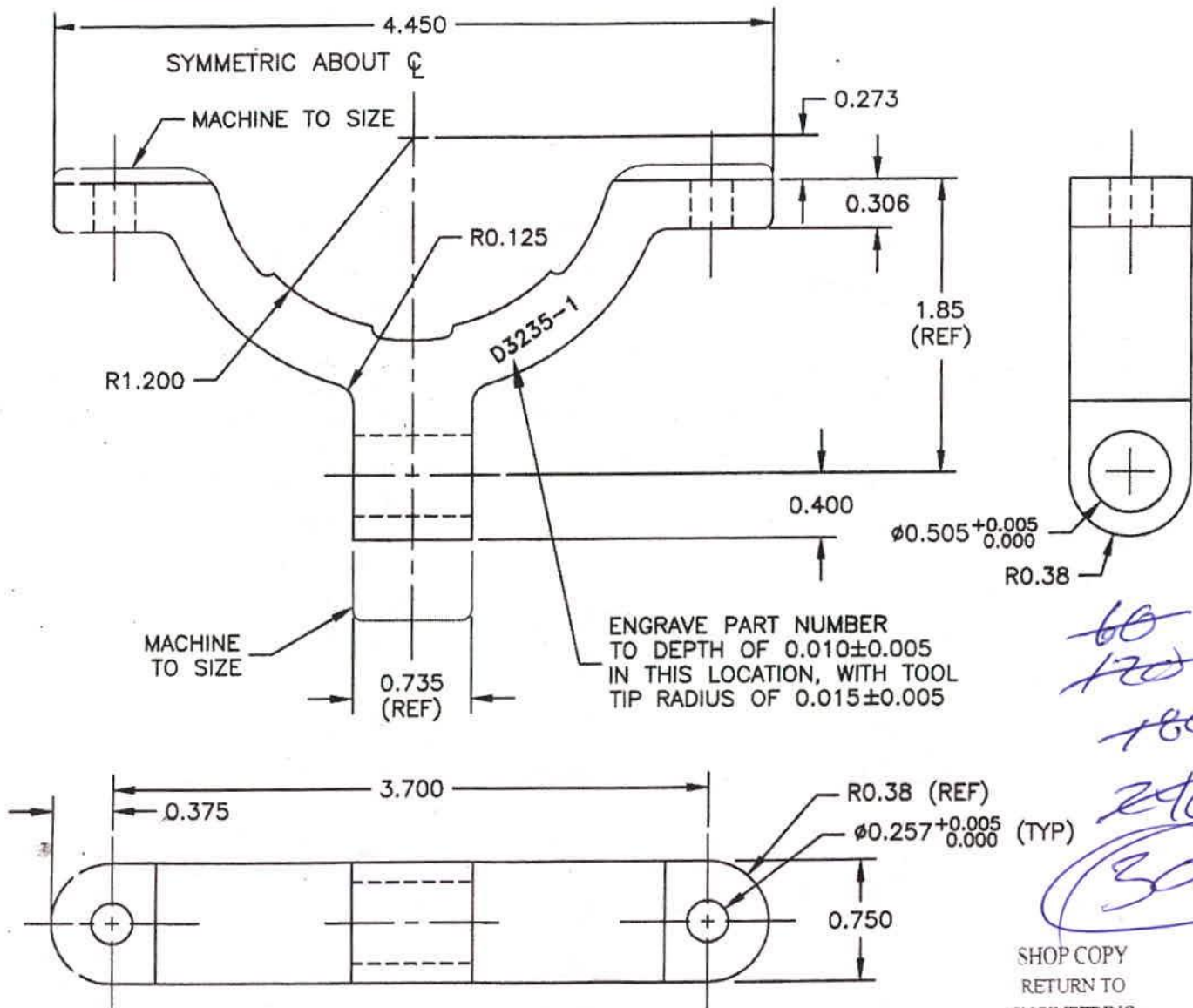
u 07/08/27

Job Completion



DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405**D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **33249**

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

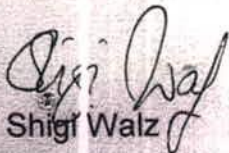
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
300	D3235-1	Mounting Lug B33249	4091

MATERIAL: supplied by DART D2423 B30062

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, August 15, 2007



7 Terry Fox Drive
Wankles Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 16093
Date: Aug 15, 2007
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 4091	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date:

	Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1	Mounting Lug	Each	500	300	
MATERIAL 2423 B30062	supplied by DART				
D3235-1	Mounting Lug ✓	Each	500		
D3338-1	Mounting Lug	Each	20		
D3394-3	Lug	Each	40		
7/8/15					
Received by _____			Thank you for your order!		